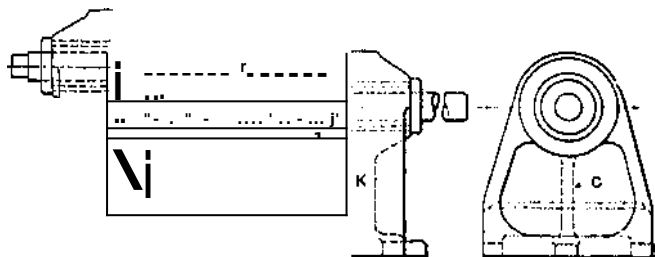
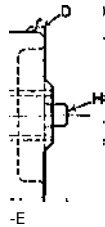


The places in the jig where the bushings are located should be provided with plenty of metal so as to give the bushings a substantial bearing in the jig body. Smaller jigs should be provided with a tongue or lip on the surface which is clamped to the machine table; this permits the operator to quickly locate the jig in the right position. As an alternative, finished lugs locating against a parallel or square may be provided. It is frequently advantageous to have small sized boring jigs provided with feet so that they can be used on a regular drill-



**Fig. 1. General
Outline of Simple
Boring Jig**

press table in cases where
holes to be bored out are to

be opened up with a drill piercing the solid metal. It is both easier and cheaper to do this rough drilling in a drill press.

The guide bushings, of the same type as the bushings for drill jigs, are made either of cast iron or steel and ground to fit the boring-bar, which is also ground. The bushings should be made rather long to insure good bearing.

Boring Jig of Simple Design. — The most common type of boring jig for small and medium size work is shown in Fig. i. In this engraving, *A* represents the work which is held down by straps or clamps. In many instances when the work is